



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.9701
Job Sheet 171894



Part No: 646.9701

Job Qty: 1 ea

Part Name: Cutter Sub Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/9/18

Job Tracking No:

Due Date: 2/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D2 SHEET 1 IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS IPP REV :B AS PER REV D 16-03-07 JLM VERIFIED BY:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	2/22/18	2/22/18	0.00	0.00	Start Up Stores/Pkg-2		FEB 09 2018
110	Packaging	1 pcs	2/22/18	2/22/18	0.00	0.00	Packaging1-1		FEB 09 2018
120	Small Fab	1 pcs	2/23/18	2/23/18	0.00	0.03	Small Fab-1		DAS 38
130	QC	1 pcs	2/23/18	2/23/18	0.00	0.00	QC5		38
140	Packaging	1 pcs	2/23/18	2/23/18	0.00	0.00	Packaging3-1		FEB 13 2018
150	QC21-SA	1 Ea	2/23/18	2/23/18	0.00	0.00	QC21		9-89

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces per note . A/R RTV LOCTITE 598: 5019005
Descriptions: exp. date: 02/19

140 - ***IDENTIFY AS PER IAW MPP-120***

DAS
21
9-89

FEB 13 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.9710	Body	1 Ea (1 ea)	90-Start up Operation	
646.9711	Blade	2 Ea (2 ea)	90-Start up Operation	
MS21042L08	Nut	6 Ea (6 ea)	90-Start up Operation	16 879
MS27039-08-19	Screw	6 Ea (6 ea)	90-Start up Operation	27 21 5
NAS1149FN832P	Washer	12 Ea (12 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	646.9710	1	24	0
	646.9711	2	7	0
	MS21042L08	6	926	0
	MS27039-08-19	6	806	0
	NAS1149FN832P	12	4,476	0

Part Specifications

Specifications could not be found.

060699

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval _____
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Description Work Order Deviation

Start up Operation 02/09/18 Job No: 171894		Completed By _____ I / Supervisor _____ I Verification _____
PART NO: 646.9701 Original Serial #: S040820 Revision: Operation: Change No:		Coordinator approval _____

Root Cause		Cutter Sub Assembly	
Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐	Pressure/Force ☐ Bending ☐ Centre Not Co ☐ Cracks ☐ Crimp/Kink/R ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐
OTHER : _____		Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	



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Master Unit 000699

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Containers on Master Unit 000699				
Serial No	Part No	Customer Part No	Status	Quantity
S034104	646.9710		Allocated	1
S040813	646.9711		Allocated	2
S040819	MS21042L08		Allocated	6
S040818	MS27039-08-19		Allocated	6
S040817	NAS1149FN832P		Allocated	12